

Date: Tuesday, 10/06/2008 3:14:36 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE FITTING, FWD (OUTBOARD/INBOARD)	
<b>Job Number</b> :	39807	<b>Part Number</b> :	D2572	
<b>Estimate Number</b> :	10531	<b>Drawing Number</b> :	D2572 REV E	
<b>P.O. Number</b> :		<b>Project Number</b> :	N/A	
<b>This Issue</b> :	10/06/2008	<b>S.O. No.</b> :		
<b>Prsht Rev.</b> :	NC	<b>Drawing Revision</b> :	E	
<b>First Issue</b> :	1/1	<b>Type</b> :	MACHINED PARTS	
<b>Previous Run</b> :	39123	<b>Material</b> :		
<b>Written By</b> :		<b>Due Date</b> :	30/06/2008	<b>Qty:</b> 8 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<u>JUD 08.6.10</u>			
<b>Comment</b> :	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101005	Saddle Billet
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>B34874</u>		
		<u>08/07/16</u> 8
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 Program Batch No. <u>39807</u> Double check by: <u>JL</u>  1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets 4-Deburr and remove all machining marks 5-Tumble to remove shap edges.		
		<u>JL MR 08/07/16</u> 8
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
<b>Comment:</b> CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572		
		<u>MR 08/07/16</u> 8

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 10/06/2008 3:14:36 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 39807

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ML*

08/07/16

(8)

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

08/07/14

28

08/07/17

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*BR*

08/07/21

(8X)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3:30  
320°F  
4:00

*ML*

08/07/21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*BR*

08-07-22

(8)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*BR*

(8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/23

Job Completion



*mf* 08-07-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 39807
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
<b>Inspection Dwg:</b> D2572 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	7.998	8.000	8.000		
F	0.490	0.510		.503	.500	.507	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.501	.501	.500	.502		
J	1.174	1.184		1.179	1.176	1.179	1.179		
K	0.558	0.578		.569	.570	.569	.570		
L	1.174	1.184		1.179	1.178	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.496	1.495		
N	2.495	2.505		2.500	2.499	2.500	2.500		
O	3.869	3.879		3.872	3.871	3.871	3.871		
P	0.115	0.135		.127	.128	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.128	.128	.132	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.236	.238	.240	.235		
W	0.115	0.135		.135	.130	.131	.130		
X	0.307	0.312		.307	.307	.307	.307		
Y	0.760	0.765		.760	.760	.762	.760		
Z	0.352	0.372		.364	.364	.366	.365		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.628	.628	.627	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.247	.243	.247		
AE	1.375	1.395		1.387	1.388	1.386	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.251	.250	.252	.249		
AI	2.000	2.020		2.004	2.004	2.002	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>amr</i>
Date: 08/07/15

Audited by: <i>LS</i>
Date: 08/07/17

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 39807
<b>Description:</b> Saddle, Fwd Inboard	<b>Part Number:</b> D2572
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K	0.558	0.578		.570	.569	.569	.571		
L	1.174	1.184		1.179	1.180	1.179	1.180		
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Measured by:	MR
Date:	08/07/15

Audited by:	RF
Date:	08/07/17

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Part No:
PAR #:
Fault Category:
NCR: Yes No
DQA:
Date:

QA: N/C Closed:
Date:

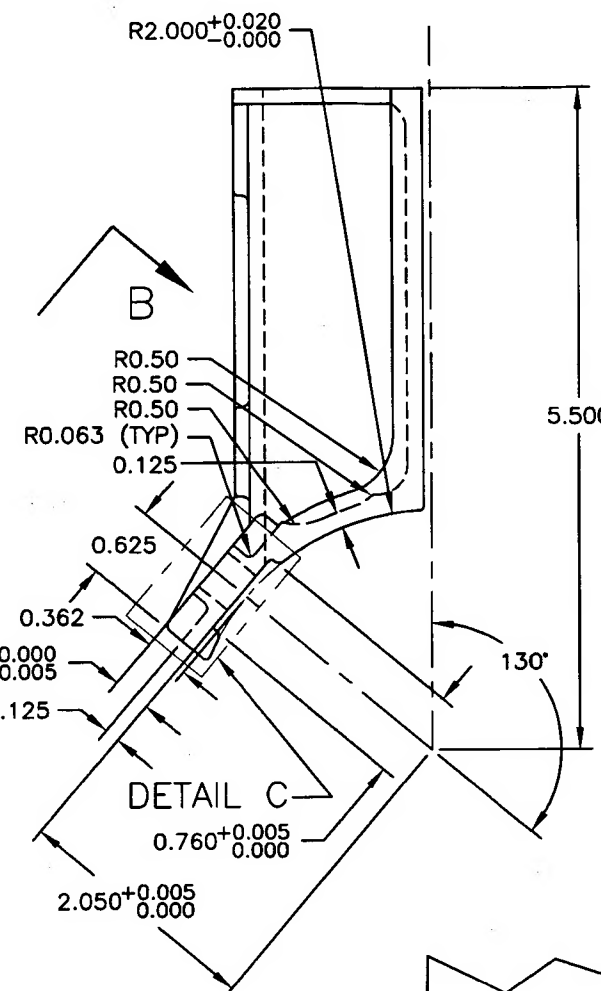
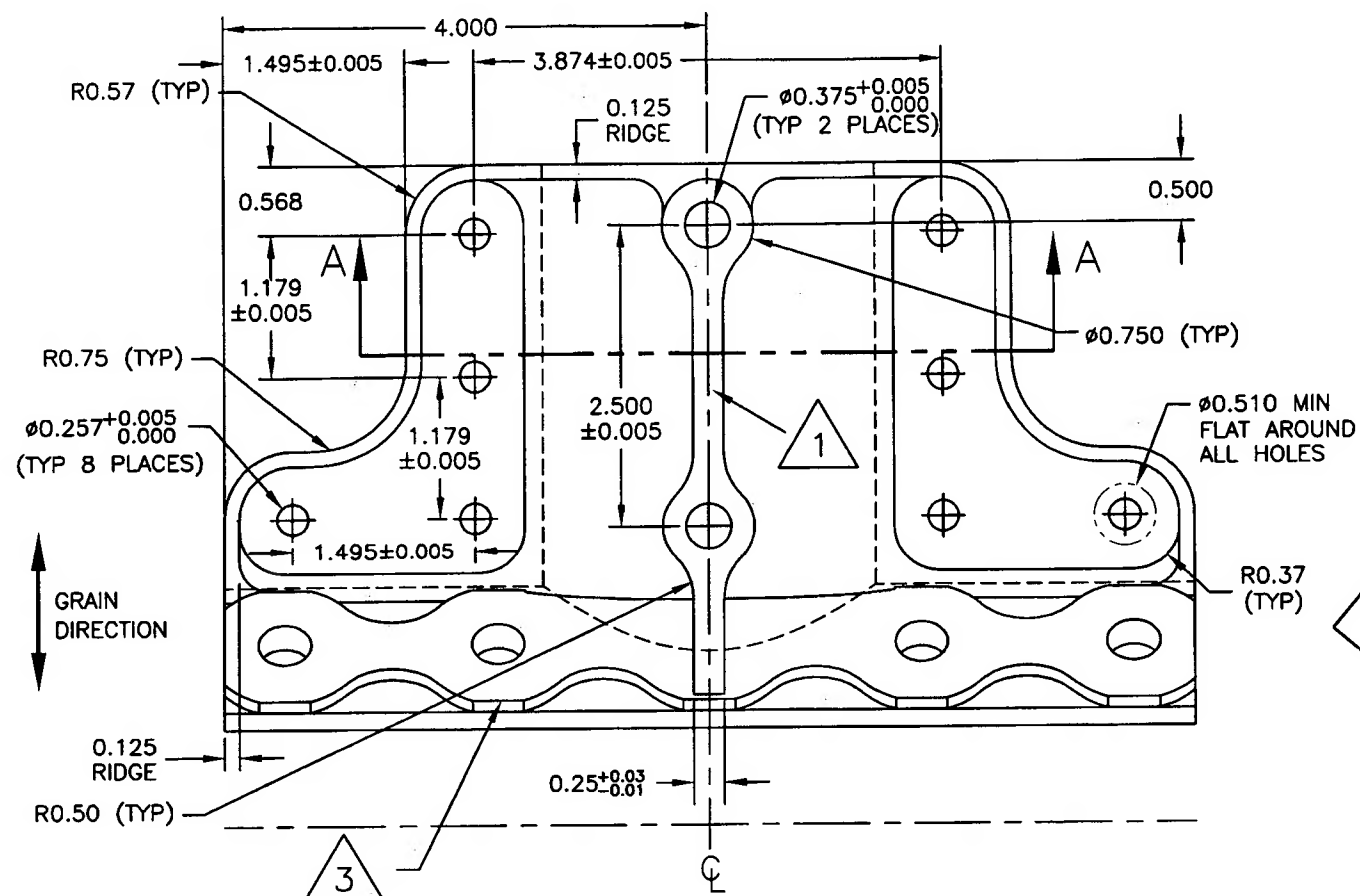
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED

05.12.06

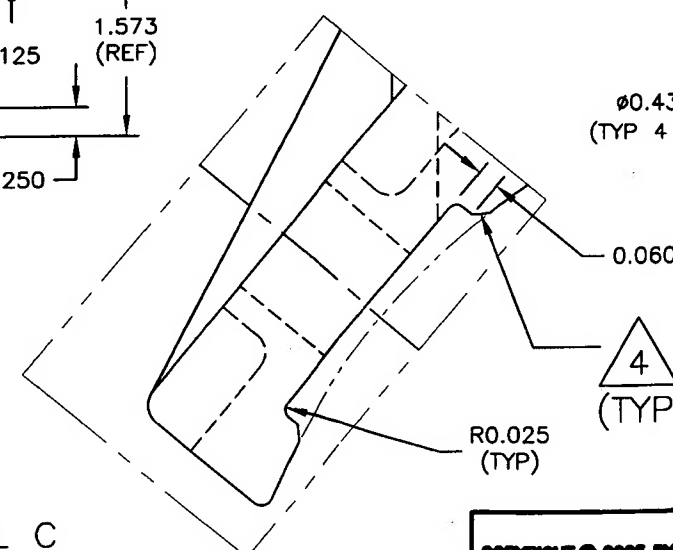
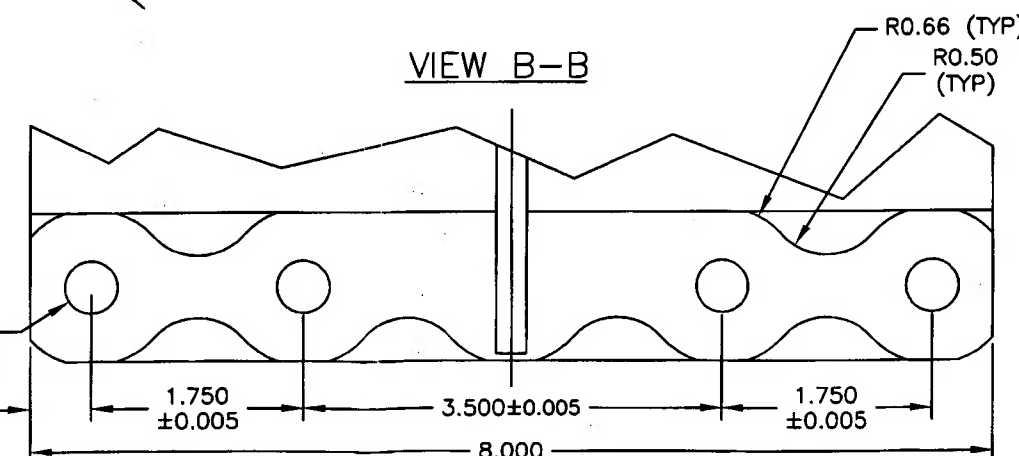
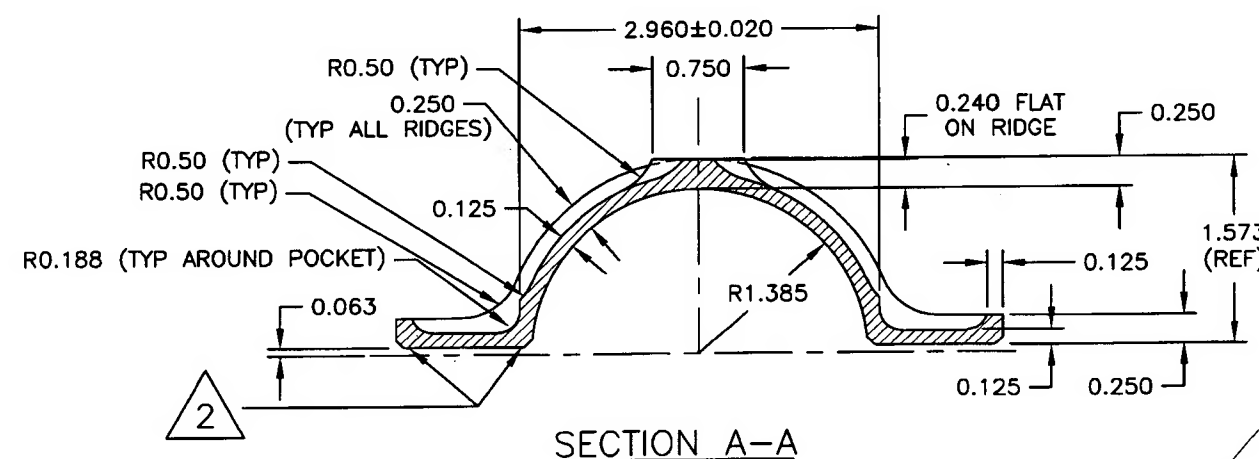


# NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)  
(REF DART SPEC. D6102-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER



DETAIL C  
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

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PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD.

DESIGN DS	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2572	REV. E SHEET 1 OF 1
DATE 05.07.13	TITLE INNER FWD SADDLE	SCALE 2:3	

